

Work Order ID 78180

January-02-12 8:50:12 AM

SHIP
24 JAN 13
78180

Page 1

Item ID: D4055-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 02/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan: *M.L.S*

Date: *12/01/02* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4055

B

100

Weld per dwg A/R Aluminum rod Batch: *114514*
119712 0.00

100

Large Fab

Large Fab

Memo

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

12.01.18 *1* *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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N900040100

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Stop ***NS2***

Start Date: 02/01/2012 Start Qty: 1.00 ***1***
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Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	BE12-01-18	
121 *121* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>WA</i> Memo I-Weld top D4055-1	0.00 0.00				1	0		<i>12-01-30</i>
122 *122* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	BE12-01-31	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC5- Inspect part completeness to step on W/O	0.00							
123									
QC	Memo	0.00							
Quality Control	***Pressure Test as per dwg D4055***								

W/O: 78180

Perm Change

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/14/31	140	Change to Qc 7	M-1 12/22/31	12.02.03			S 12/23/31

Part No: D4055-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Powdercoat Powder Coating	Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3 PS311 A13 Cherry Memo ***Mask prior to powdercoat*** Start Time: 9-20 Oven Temperature: 320 F Finish Time: 9-50	0.00 0.00							12/02/01
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1 BL 12-2-1.
185 *185* SprayPaint Spray Painting	Memo Seal inside of tank using Sloshing PR-1005 L Sealer as per dwg	0.00 0.00							

W118533

5/21/31

u/45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100

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Stop *NS2*

Start Date: 02/01/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 24/01/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

0,00

190

0.00

Small Fab

Memo

Assemble as per dwg

+ DST 9577 04

200

QC5- Inspect part completeness to step on W/O

0.00

200

0.00

QC

Memo

Quality Control

220

QC5- Inspect part completeness to step on W/O

0.00

220

0.00

QC

Memorandum

Quality Control

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 Required Date: 24/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo <i>PM 78339</i>	0.00							<i>Carp/2</i>
Packaging									<i>C</i>
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							<i>12/2/2</i>
Quality Control									<i>ME</i> <i>12-02-02</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 78180

78180

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verified by:DD IPP Rev D: 11.06.01 per D4055
revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 *D3997-1* Placard		Manufactured	No			190	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				4					
					73509			4					
D3997-5 *D3997-5* Placard		Manufactured	No			190	Each	13.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				103					
					72611			95					
					73507			8					
D3997-11 *D3997-11* Placard		Manufactured	No			190	Each	11.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				11					
					72614			2					
					73510			9					

**

379411

SD

**

SD

**

SD

2/2/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID: 78180

78180

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-17

Manufactured No

190 Each

11.0000

1

D3997-17

**

Placard

Location

Loc Qty

Loc Code

ST104

11

72617

2

73513

9

D3997-29

Manufactured No

190 Each

13.0000

1

D3997-29

**

Placard

Location

Loc Qty

Loc Code

ST104

13

72622

3

73511

10

D3997-43

Manufactured No

190 Each

11.0000

1

D3997-43

**

Placard

Location

Loc Qty

Loc Code

ST104

11

72629

1

73512

10

D3999-7

Manufactured No

100 Each

16.0000

1

D3999-7

**

Corner

Location

Loc Qty

Loc Code

WA014

16

71695

2

75156

14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 78180

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Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-9 Manufactured No

100 Each 7.0000 1 1

D3999-9

Angle

**

12.01.14

Location

Loc Qty

Loc Code

WA014

7

71696

7

D3999-11 Manufactured No

100 Each 9.0000 1 1

D3999-11

Earth Tab

**

12.01.18

Location

Loc Qty

Loc Code

WA

8

WA013

-8

WA014

9

71694

1

75180

8

D3999-041 Manufactured No

100 Each 6.0000 1 1

D3999-041

Baffle Assembly, Aft

**

12.01.14

Location

Loc Qty

Loc Code

WA014

6

72653

2

75230

4

D3999-043 Manufactured No

100 Each 3.0000 1 1

D3999-043

Baffle Assembly, Fwd

**

12.01.14

Location

Loc Qty

Loc Code

WA014

3

74961

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 78180

78180

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-1 Manufactured No

100

Each

4.0000

1

1

D4000-1

Fuel Supply Fitting

**

12.01.22

Location

Loc Qty

Loc Code

WA014

4

74835

4

1

D4000-5 Manufactured No

100

Each

4.0000

1

1

D4000-5

Fuel Tank Vent Fitting

**

12.01.16

Location

Loc Qty

Loc Code

WA014

4

74833

4

1

D4000-9 Manufactured No

100

Each

3.0000

3

3

D4000-9

Grommet

**

12.01.14

Location

Loc Qty

Loc Code

WA014

3

73646

3

3

D4000-043 Manufactured No

100

Each

0.0000

1

1

D4000-043

Drain Fitting Assembly, Fwd

**

B 78379
B 75225 = (1)

12.01.14

D4000-045 Manufactured No

100

Each

2.0000

1

1

D4000-045

Fuel Pickup Fitting Assembly

**

12.01.22

Location

Loc Qty

Loc Code

WA013

1

72078

1

WA014

1

71669

1

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-041

Manufactured No

D4000-041

Drain Fitting Assembly, Aft

D4001-1

Manufactured No

D4001-1

Fitting

D4008-11

Manufactured No

D4008-11

Hinge Half

D4008-041

Manufactured No

D4008-041

Fuel Filler Splash Guard Assembly

D4023-3

Manufactured No

D4023-3

Cap and Flange

Location

Loc Qty

Loc Code

WA014

4

74831

4

100

Each

5.0000

1

1

**

Location

Loc Qty

Loc Code

WA014

5

75228

5

190

Each

6.0000

1

1

**

Location

Loc Qty

Loc Code

ST108

6

72792

6

100

Each

8.0000

1

1

**

Location

Loc Qty

Loc Code

ST110

8

73514

8

B 75232 #1

12.01.14

12.01.16

12.01.18

12/2/11

12.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4025-1 Manufactured No

100 Each

5.0000

1

1

D4025-1

Fuel Quantity Sender

**

[Signature]

Location

Loc Qty

Loc Code

ST141a

5

71765

4

72257

1

D4055-11 Manufactured No

100 Each

11.0000

1

1

D4055-11

Tank Front and Bottom

**

[Signature] 12.01.13

Location

Loc Qty

Loc Code

WA014

11

65447

2

68500

3

72249

1

74908

5

D4055-9 Manufactured No

100 Each

5.0000

1

1

D4055-9

Tank Back

**

[Signature] 12.01.16

Location

Loc Qty

Loc Code

WA014

5

75125

5

D4055-7 Manufactured No

100 Each

7.0000

1

1

D4055-7

Tank Fwd End

**

[Signature] 12.01.22

Location

Loc Qty

Loc Code

WA014

7

73476

4

74955

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4055-5 Manufactured No

100

Each

6.0000

1

1

D4055-5

Tank Upper Cut Out

**

12.01.22

Location

Loc Qty

Loc Code

ST119

373476

1

72250

1

WA014

5

74907

5

D4055-3 Manufactured No

100

Each

7.0000

1

1

D4055-3

Tank Aft End

**

12.01.22

Location

Loc Qty

Loc Code

WA014

7

73475

3

75224

4

D4055-1 Manufactured No

100

Each

2.0000

1

1

D4055-1

Tank Top

**

12.01.16

Location

Loc Qty

Loc Code

WA014

2

71701

2

D4057-1 Manufactured No

100

Each

23.0000

3

3

D4057-1

Retaining Ring

**

12.01.14

Location

Loc Qty

Loc Code

WA013

23

71166

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 02/01/2012

Required Date: 24/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3H5A Purchased No

190 Each 22.0000 5 5

AN3H5A

**

Bolt

Location

Loc Qty

Loc Code

ST351

22

116704

1

118112

21

NAS1149D0363J Purchased No

190 Each 2,232.000 5 5

NAS1149D0363J

**

Washer

Location

Loc Qty

Loc Code

ST298

2232

117601

61

118077

1

118612

18

118968

137

119537

2015

D4404-1 Manufactured No

190 Each 10.0000 1 1

D4404-1

**

Cushion

Location

Loc Qty

Loc Code

ST242A

10

75181

7

76569

3

D4404-5

B- 76899

D4404-7

B- 79119

D4404-9

B- 79120

mk1
sp

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

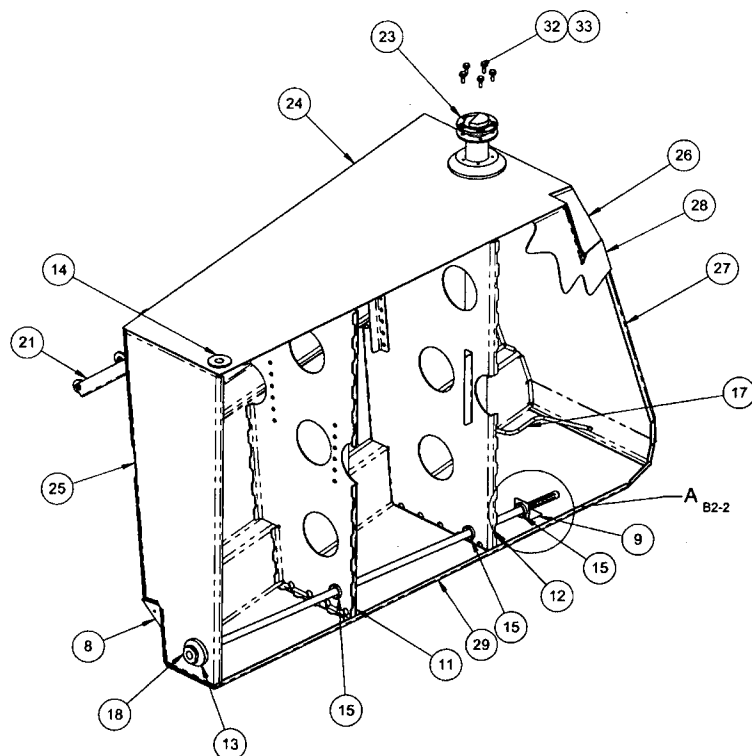
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

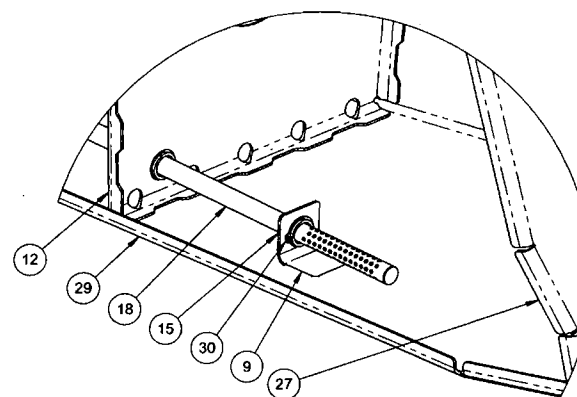
NOTE: Date & initial all entries

78180

RELEASED
2011-05-30



**D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL**



**DETAIL A
ROTATED FOR CLARITY
SCALE 2X**

B6-2

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 2 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

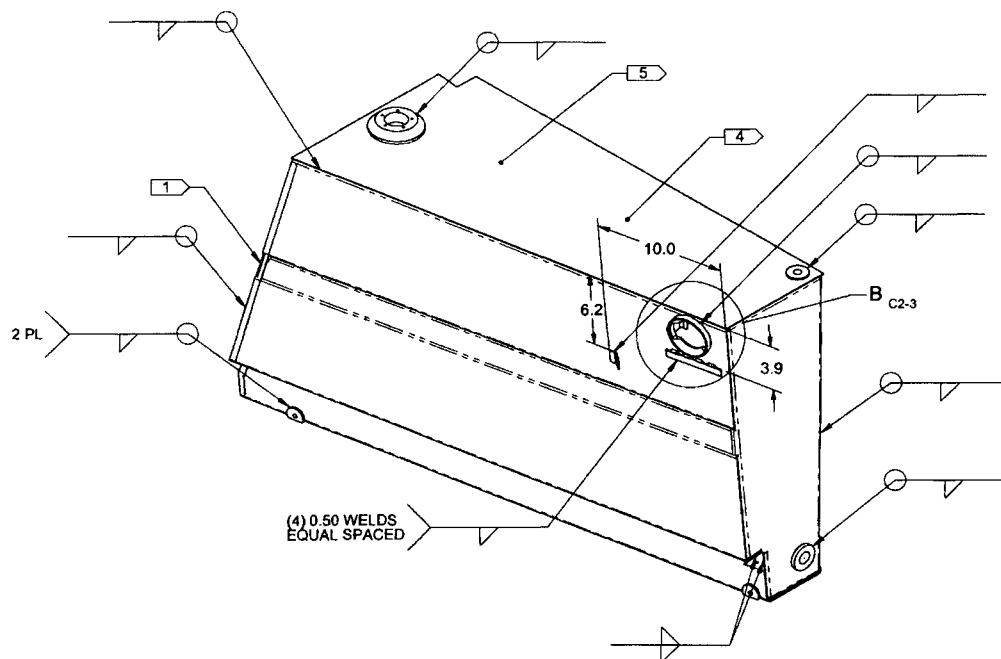
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

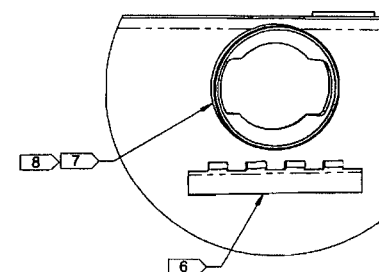
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180



**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**



**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**

C4-3

RELEASED
2011-05-30
MM

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 3 OF 15
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

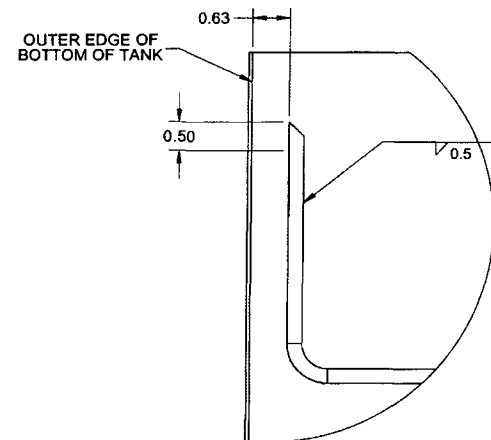
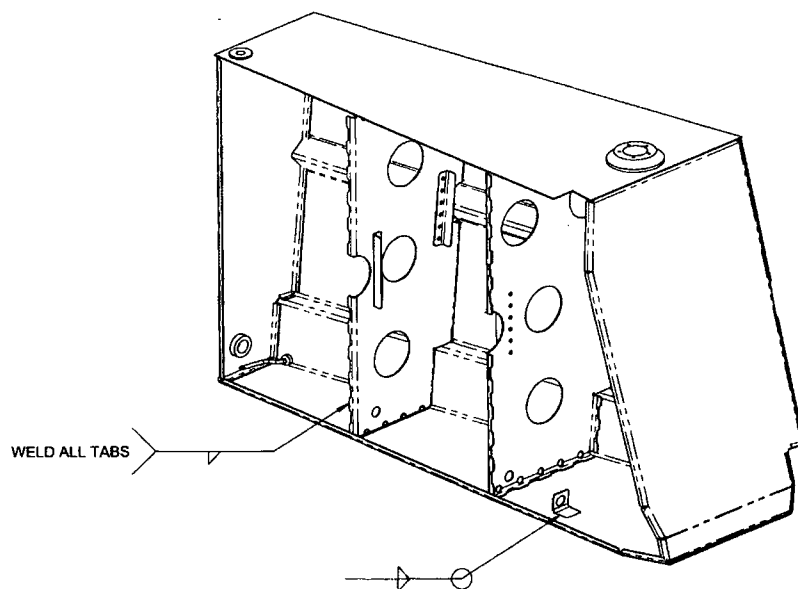
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180



**DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE**

**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

RELEASED
2011-05-30
JW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 4 OF 15
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

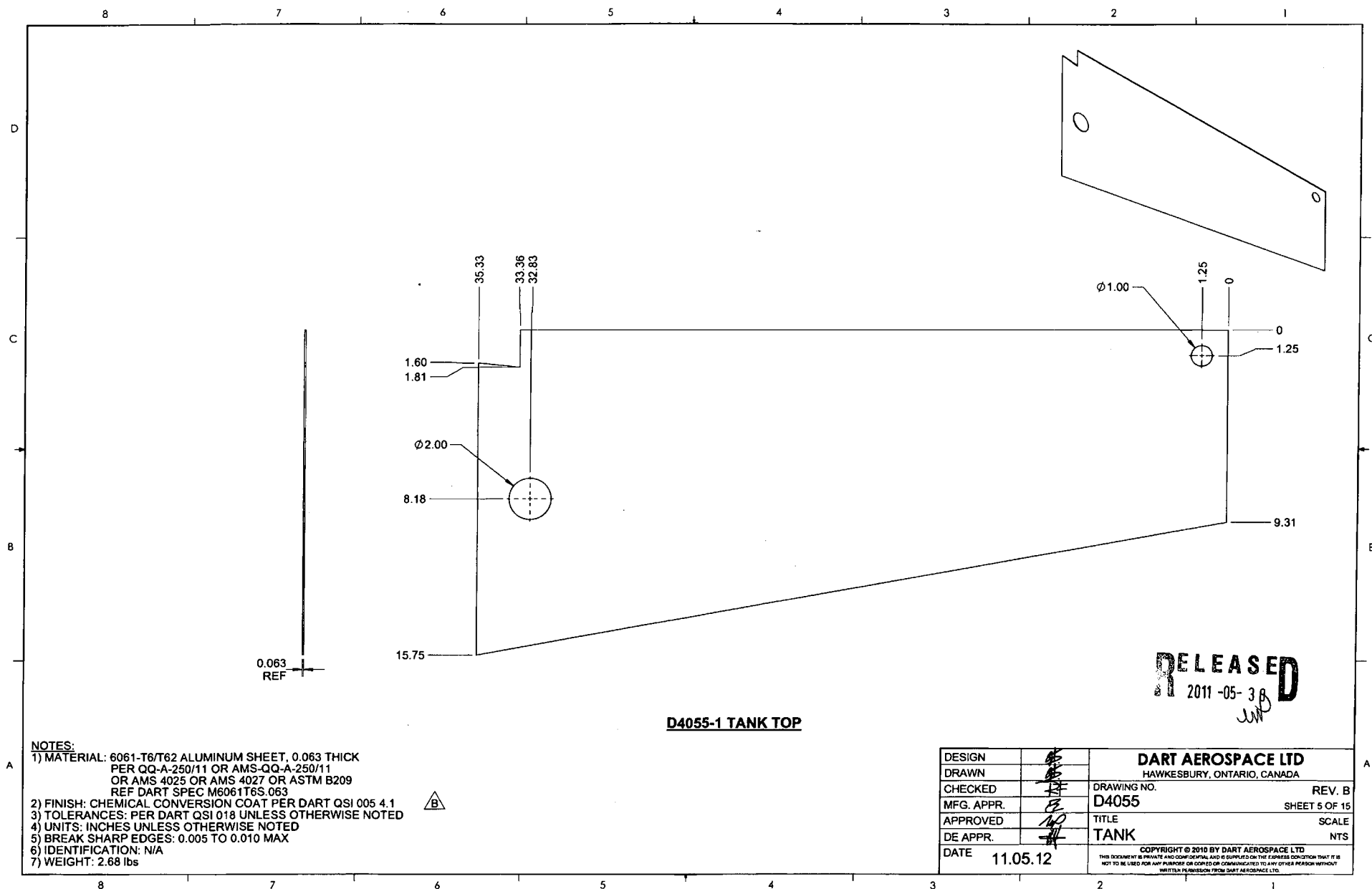
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

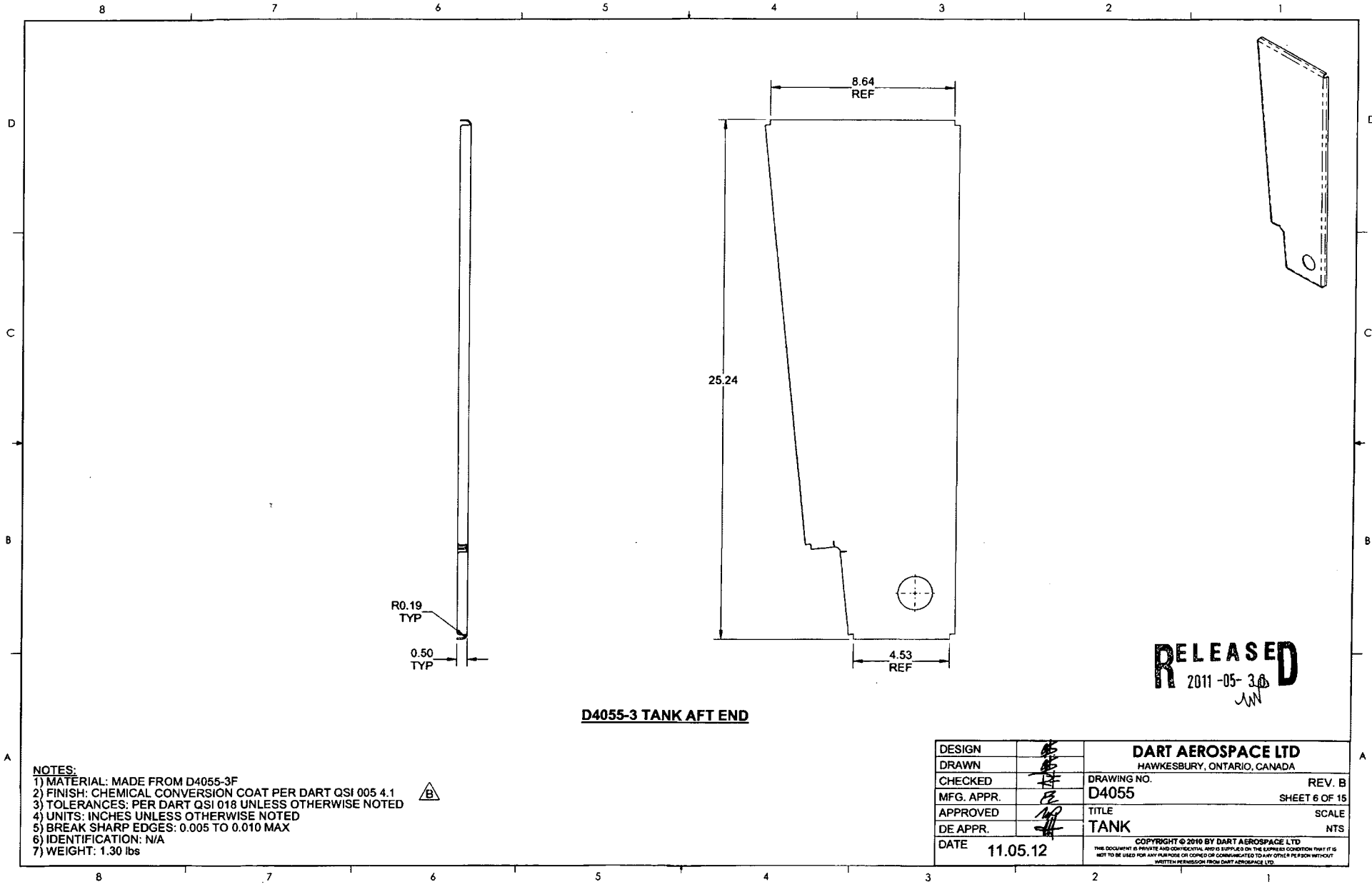
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180



D4055-3 TANK AFT END

RELEASED
2011-05-30
JN

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs



DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4055	SHEET 6 OF 15
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

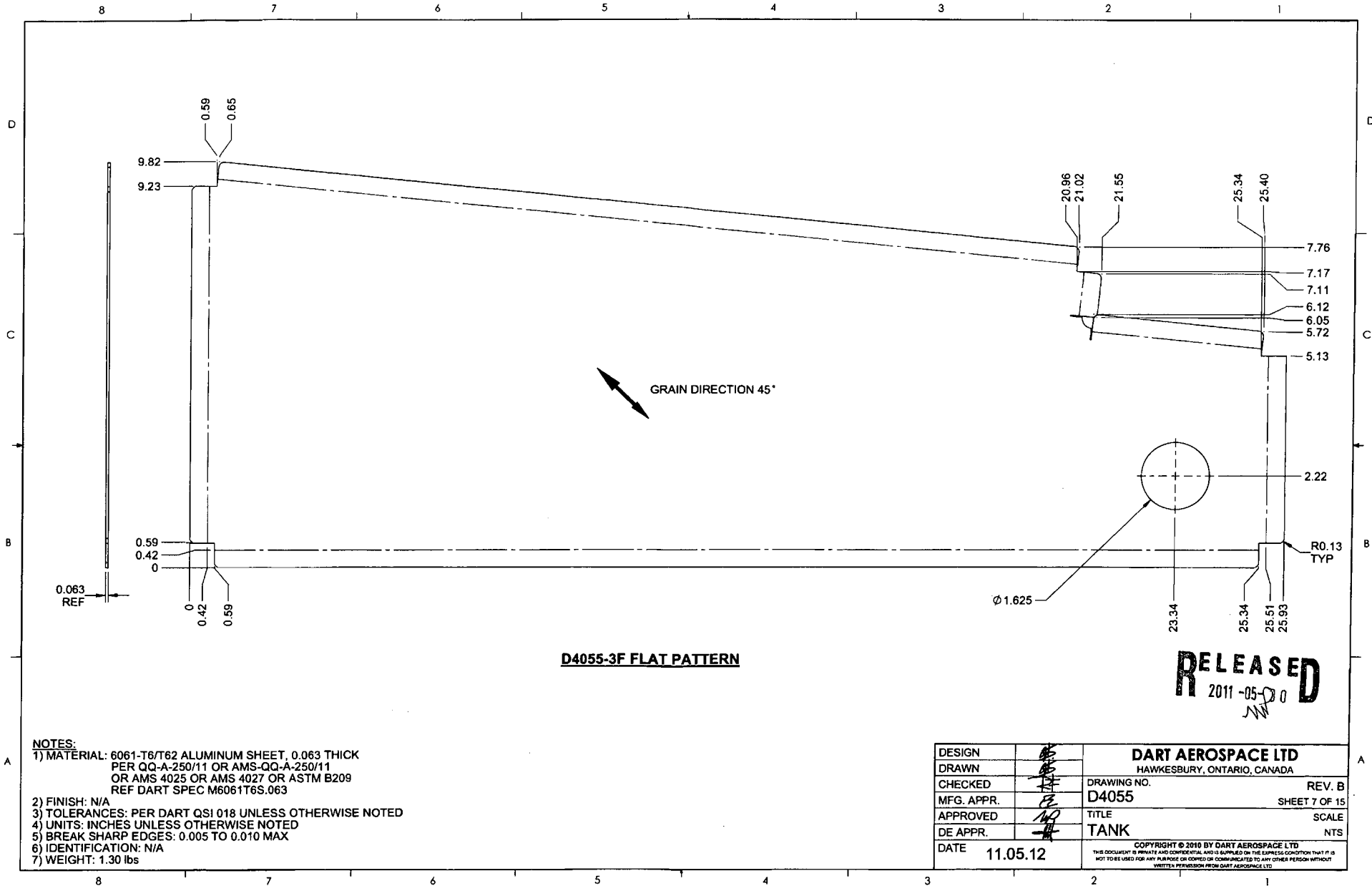
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____







NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180



- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4055	SHEET 7 OF 15
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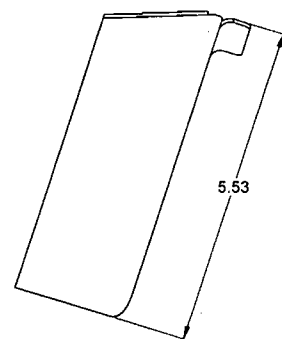
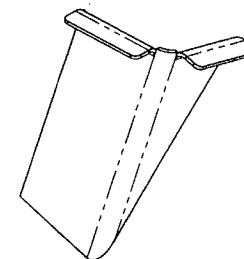
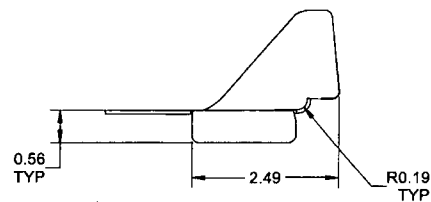
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180



D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
NN

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		SHEET 8 OF 15	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

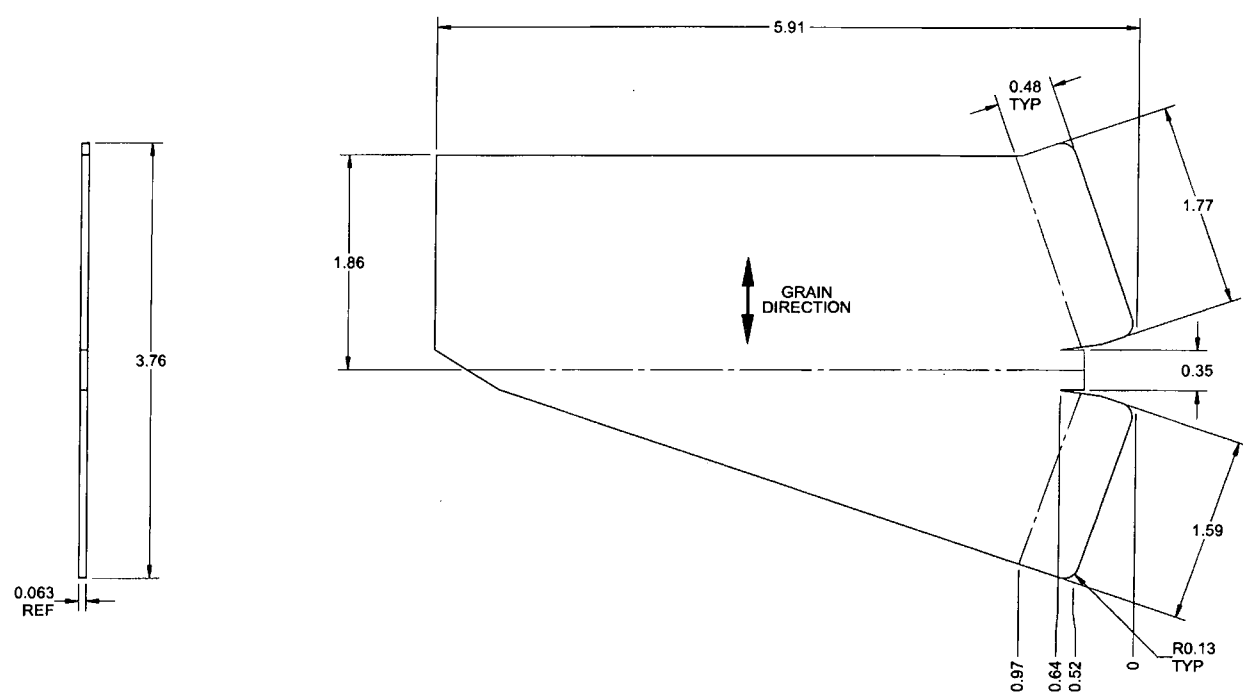
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180



D4055-5F FLAT PATTERN

RELEASED
2011-05-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 9 OF 15
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

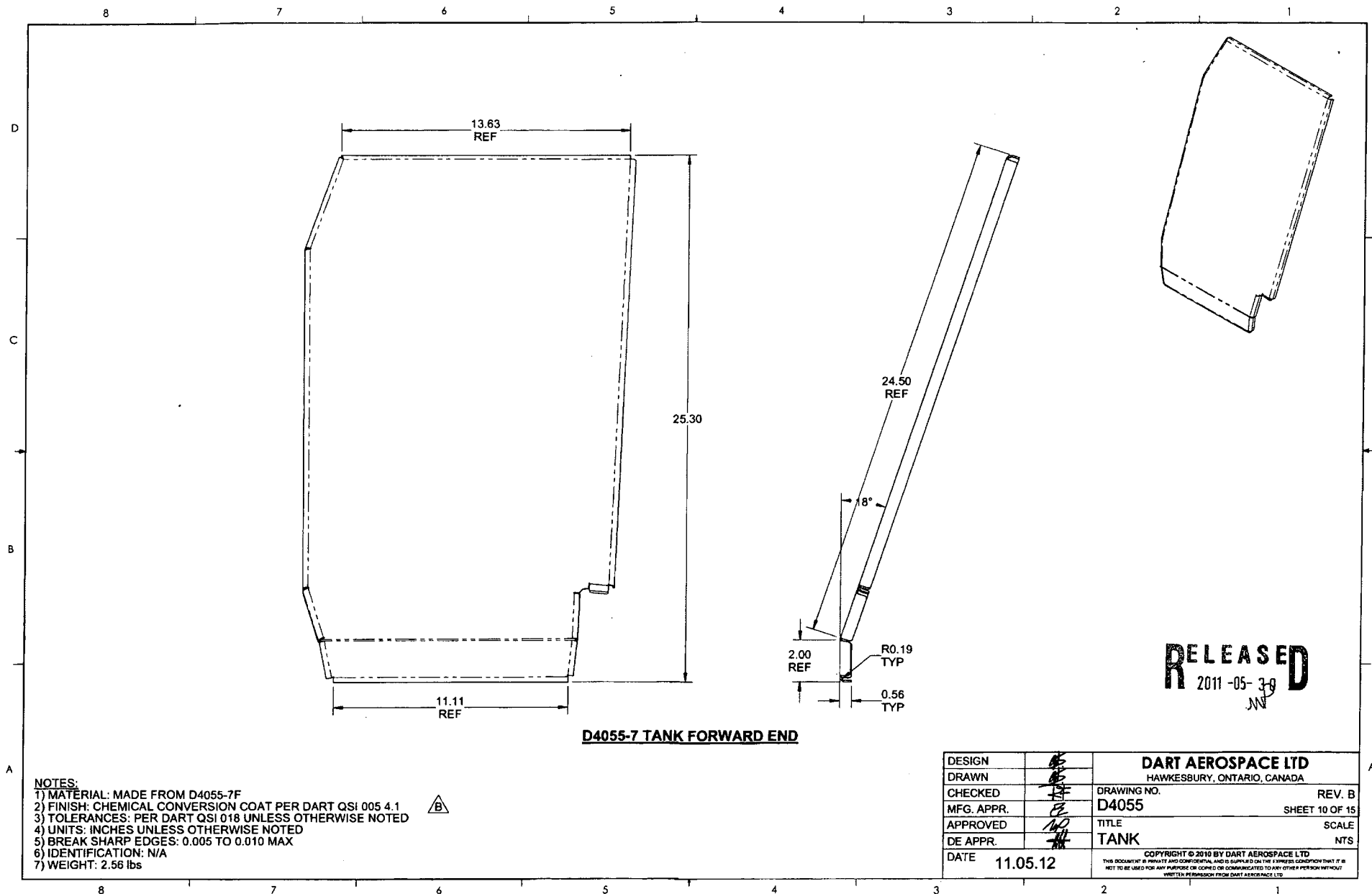
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180









NOTES:

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs



RELEASED
2011-05-30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4055	SHEET 10 OF 15
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2



C

B

- A

A

RELEASED
2011-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

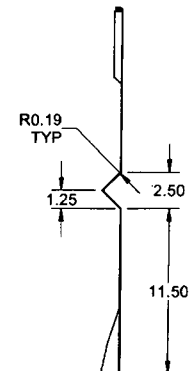
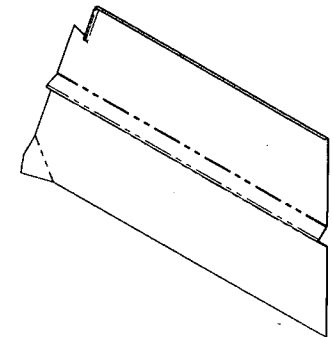
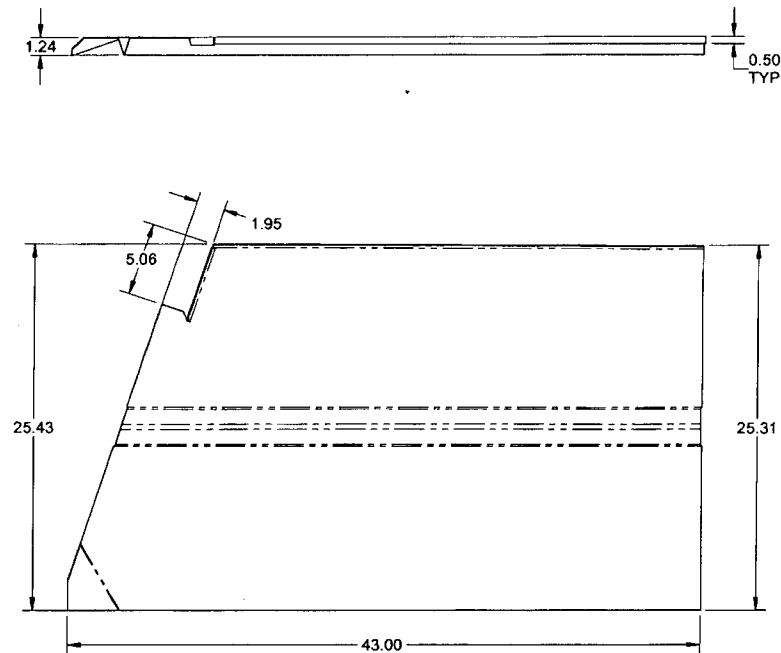
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72180



D4055-9 TANK BACK

RELEASED
2011-05-30

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 15
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a flat pattern for a tank. The drawing shows a rectangular main body with a width of 33.28 and a total width of 39.54. The height is divided into sections with dimensions 0.42 REF, 1.73 REF, 1.73 REF, 11.48 REF, and 26.59. A grain direction arrow points vertically. The right side features a complex shape with dimensions 9.44, 6.48, 4.21, 4.14, 3.31, 3.24, 1.01, 0.07, and 0. A diagonal section has dimensions 1.52, 4.80, and 3.76. A vertical dimension of 26.36 is shown on the right. A release stamp is present on the right side.

RELEASED
2011-05-30

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 6.41 lbs

D4055-9F FLAT PATTERN

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4055 MFG. APPR. [Signature] APPROVED [Signature] DE APPR. [Signature] DATE 11.05.12	REV. B
DRAWN			SHEET 13 OF 15
CHECKED			SCALE
TITLE	TANK		NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

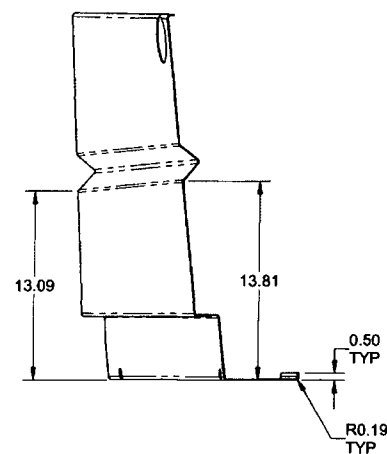
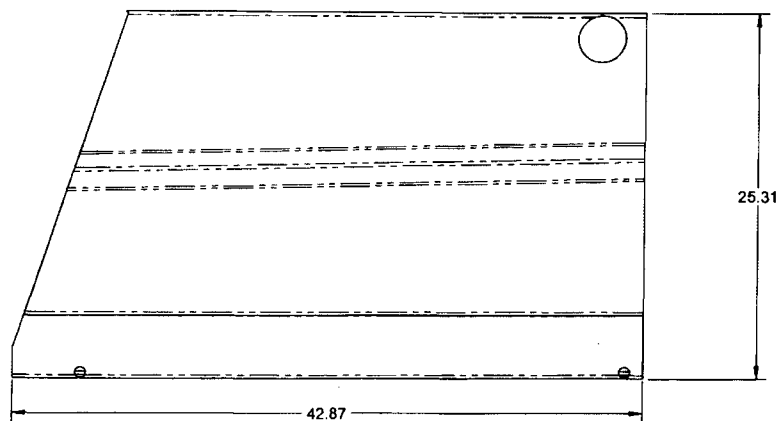
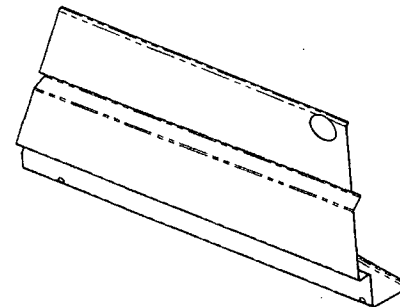
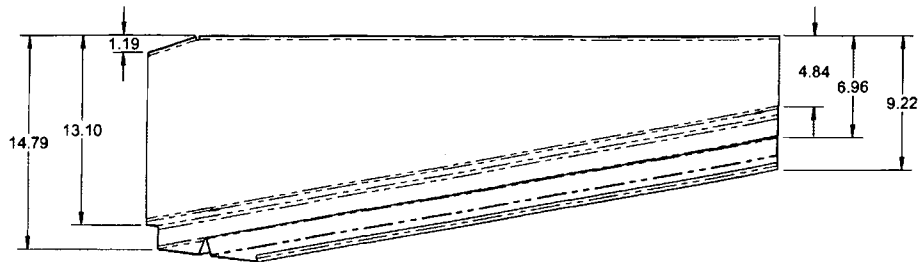
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78180



D4055-11 TANK FRONT AND BOTTOM

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

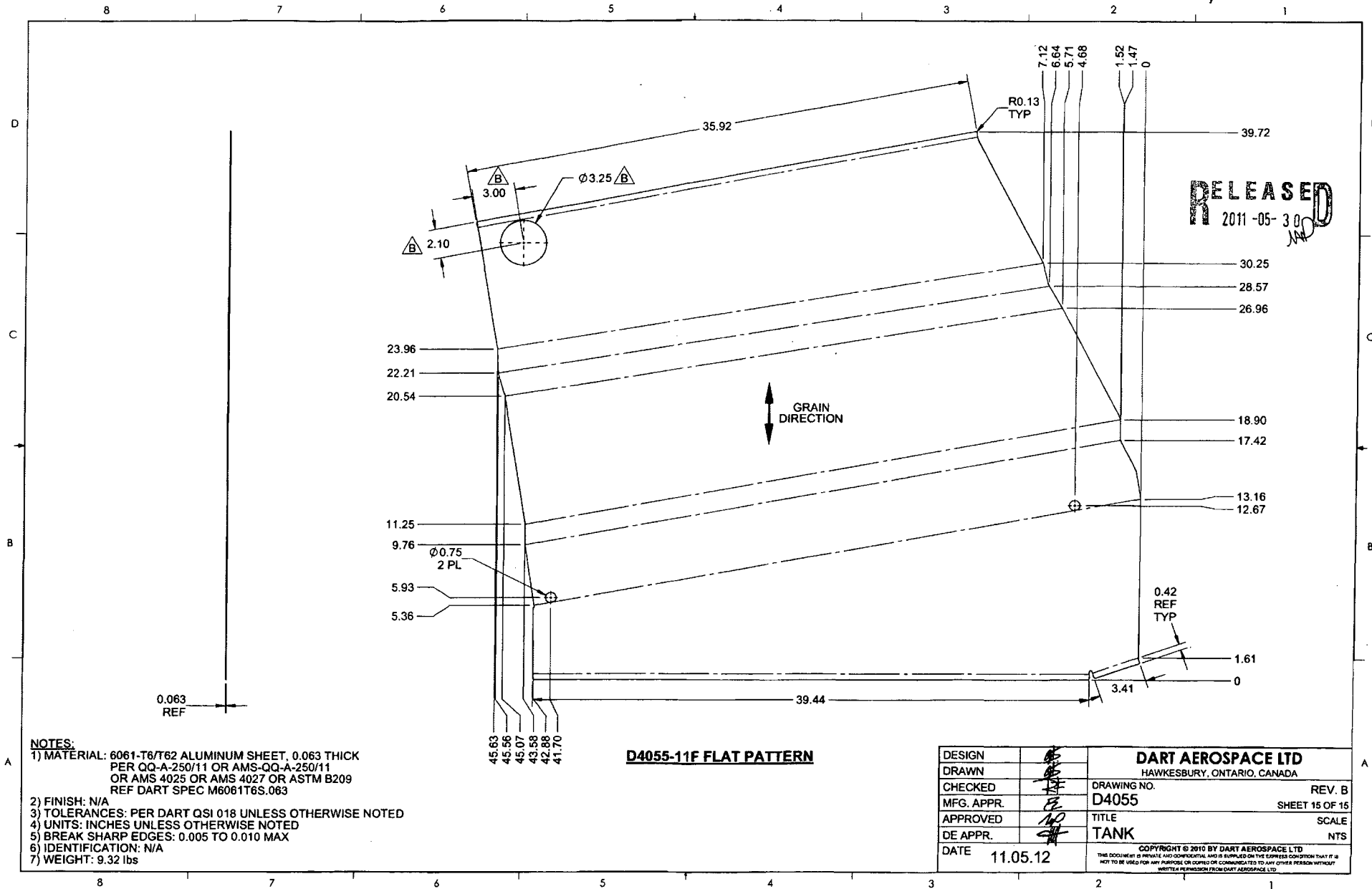
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







78180



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs

D4055-11F FLAT PATTERN

DESIGN		DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-794 REV. C OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-794 REV. 2 OR EARLIER

REF. TCCA STC: SH05-4
REF. EASA STC: 10031514
REF. BRAZIL STC: 2002S09-07/-08
REF. AUSTRALIAN STC: ASR063SY

PURPOSE:

TO PROVIDE INSTRUCTIONS THAT ALLOW INSTALLATION OF D4404-1/-5/-7/-9 NEOPRENE CUSHIONS TO PREVENT THE D4055-041 AUX. FUEL TANK FROM CHAFING IN SERVICE.

CHANGE:

D350-794-011, D130-794-021, AND D350-794-041 KITS AT CHG 005 OR LATER ARE SUPPLIED TO CUSTOMERS/OPERATORS WITH D4404-1/-5/-7/-9 NEOPRENE CUSHIONS INSTALLED ON D4055-041 AUXILIARY FUEL TANK. CUSTOMERS/OPERATORS WITH D130-794-021 AND D350-794-041 KITS AT CHG 004 AND EARLIER CAN PROCURE DSI-9577-011 KIT FROM DART TO UPGRADE THEIR KITS.

PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9577-011	CUSHION INSTALLATION
1	D4404-1	CUSHION
1	D4404-5	CUSHION, FWD
1	D4404-7	CUSHION, UPPER SIDE
1	D4404-9	CUSHION, LOWER SIDE

INSTALLATION:

INSTALL THE D4404-1/-5/-7/-9 CUSHIONS IN ACCORDANCE WITH FIGURE 1 OF THIS SERVICE INSTRUCTIONS AFTER COMPLETING STEP 5.2.8 OF THE ANNUAL/100 HOUR INSPECTION OF ICA-D350-794 BY APPLYING A THIN, UNIFORM LAYER OF CONTACT CEMENT (3M 1300/1301 SCOTCHGRIP ADHESIVE OR EQUIVALENT). TRIM TO FIT IF REQUIRED.

WEIGHT AND BALANCE:

THE FOLLOWING TABLE LISTS THE NEW WEIGHT AND BALANCE OF THE -011/-021 KITS AT CHG 005 OR LATER OR AFTER DSI-9577-011 KIT HAS BEEN INSTALLED.





INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D350-794-011 AUXILIARY FUEL TANK (CHG 005) (AS350 MODELS)	32.7 lb 14.8 kg	-22.0 in -0.56 m	-719.4 in-lb -8.29 m-kg	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kg
D130-794-021 AUXILIARY FUEL TANK (CHG 005) (EC130 MODELS)	32.7 lb 14.8 kg	-23.6 in -0.60 m	-771.7 in-lb -8.88 m-kg	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kg

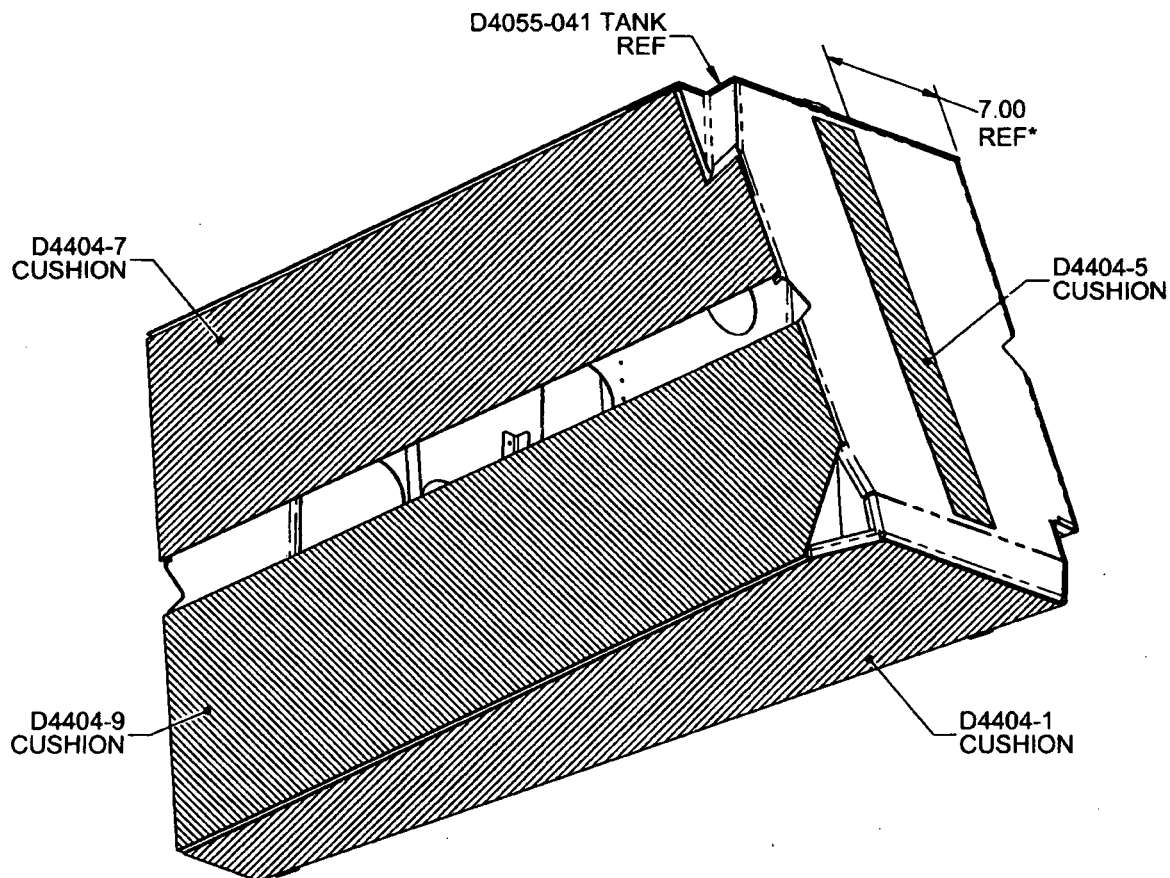
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

A	NEW ISSUE	MB	11.10.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION INSTALLATION	NTS
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




*: ALIGN D4404-5 WITH FORWARD RESTRAINT BEAM (EXISTING ON AS350, D4005-3 ON EC130)

FIGURE 1 - CUSHION INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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